Work Order ID 86663

July-06-12 11:18:05 AM

86663

Item ID: D2896-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Support

Start Date: 7/06/12 **Start Qty:** 12.00 *12*

Required Date: 8/03/12 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** 12-07-6 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2896 / C									
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1					12	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA167 Folio Rev: AA Dwg Rev: C								
	Deburr								
	****Program Batch #**********								
110	QC1- Inspect dimensions to dimension sheet	0.00							
110						12	ϕ		
QC	**Memo**	0.00							
Quality Control									

Ba 12/08/31

ork 12/09/01

ork 12/09/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 86663

July-06-12 11:18:05 AM

86663

Item ID: D2896-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Support

Start Date: 7/06/12 **Start Qty:** 12.00 *12*
Required Date: 8/03/12 **Req'd Qty:** 12.00 *12*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				12	4		
120									
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: LG	0.00				12			12/9/10
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							12/9/11
140									
QC	**Memo**	0.00							
Quality Control									

12-8-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:18:04 AM

Work Order ID: 86663

Parent Item: D2896-1 **Start Date:** 7/06/12 **Required Date:** 8/03/12

Parent Item Name: Support **Start Qty:** 12.00 **Required Qty:** 12.00

Comments: IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ
IPP Rev:C As per Rev B 07-04-16 JLM
IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER
REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	12.0000	**0.5**	6			
D2896-1 TURNING DETAIL										12/08/31			

Location	Loc Qty	Loc Code	
MAT060	12		
→ 73927	4		3
82953	8		

89632 X 3 ok 12/09/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	8663
Description: Support	Part Number:	D2896-1
Inspection Dwg: D2896 **Rev:** ~~B~~ C		Page 1 of 1

12/07/18

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	#1	#2	#3	#4
HAAS Section								
AA	2.152	2.172			2.157	2.160	2.158	2.158
AB	2.340	2.360			2.351	2.357	2.352	2.352
AC	3.550	3.560			3.555	3.555	3.555	3.555
AD	3.770	3.790			3.780	3.780	3.779	3.780
AE	0.065 x 0.315	0.085 x 0.335			.075X.325	.075X.330	.075X.331	.075X.336
AF	1.42	1.48			1.450	1.448	1.450	1.448
AG	0.833	0.853			.850	.844	.846	.843
AH	0.240	0.260			.250	.250	.250	.250
AI	0.261	0.266		Per Rev. C	.262	.262	.262	.262
AJ	0.189	0.194			.192	.192	.192	.192
AK	~~1.990~~ 1.970"	~~2.010~~ 2.030"		12/07/18	2.001	2.000	2.003	2.000
AL	0.625	0.630			.6256	.6256	.626	.626
AM	101.75	105.75			103.75	103.75	103.75	103.75
AN	0.053	0.073			.063	.063	.063	.063
AO	0.926	0.946			.942	.942	.943	.943
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject					.0015	.001	.002	.0005

Measured by:		**Date:**	12/09/01
Audited by:		**Date:**	12-2-9
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	86663
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	**Rev:** ~~B~~ C		Page 1 of 1

12/07/18

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**#5**	**#6**	**#7**	**#8**
HAAS Section								
AA	2.152	2.172			2.162	2.163	2.163	2.159
AB	2.340	2.360			2.351	2.352	2.350	2.350
AC	3.550	3.560			3.554	3.554	3.552	3.553
AD	3.770	3.790			3.778	3.778	3.778	3.778
AE	0.065 x 0.315	0.085 x 0.335			.072X.320	.070X.315	.070X.315	.073X.320
AF	1.42	1.48			1.445	1.448	1.448	1.445
AG	0.833	0.853			.846	.844	.843	.845
AH	0.240	0.260			.250	.250	.250	.250
AI	0.261	0.266		Per Rev C	.262	.262	.262	.262
AJ	0.189	0.194			.191	.191	.191	.191
AK	~~1.990~~ 1.97	~~2.010~~ 2.030		12/07/18	2.002	1.998	1.997	2.000
AL	0.625	0.630			.626	.626	.6257	.626
AM	101.75	105.75			103.75	103.75	103.75	103.75
AN	0.053	0.073			.063	.063	.063	.063
AO	0.926	0.946			.941	.942	.942	.942
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject					.004	.0045	.0025	.001

Measured by:	CML	**Date:**	12/09/02
Audited by:	RP	**Date:**	12-5-2
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	8663
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: ~~B~~ C DS 12/07/18		Page 1 of 1

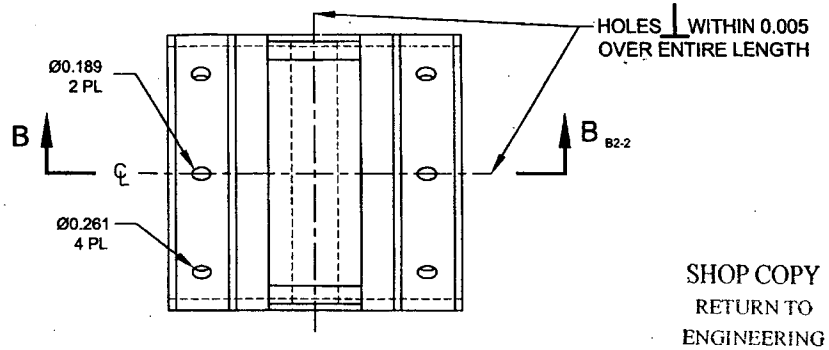
FIRST ARTICLE INSPECTION DIMENSION SHEET

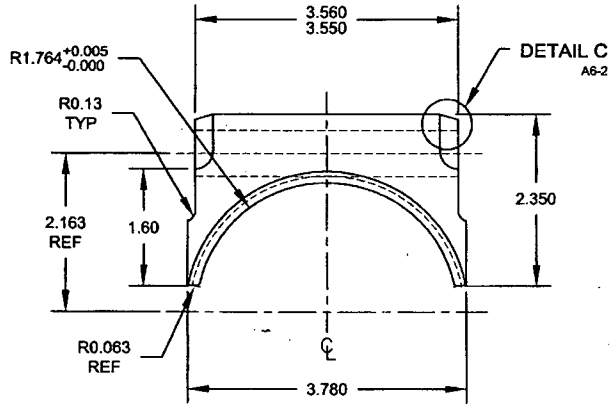
[X] First Article [ ] Prototype

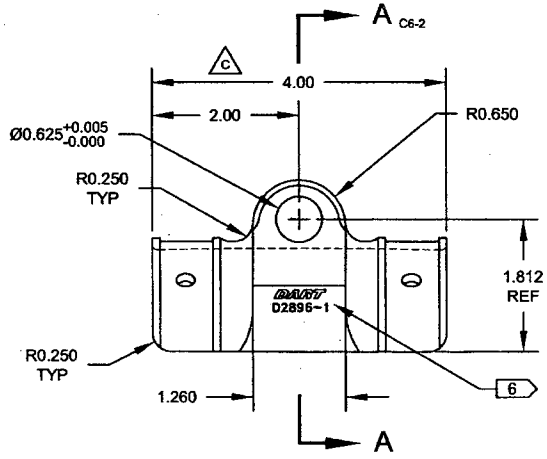
				Record Actual Dimensions				
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**#9**	**#10**	**#11**	**#12**
HAAS Section								
AA	2.152	2.172			2.158	2.161	2.159	2.161
AB	2.340	2.360			2.351	2.353	2.355	2.355
AC	3.550	3.560			3.555	3.555	3.554	3.554
AD	3.770	3.790			3.778	3.779	3.778	3.779
AE	0.065 x 0.315	0.085 x 0.335			.075X.325	.075X.325	.075 x.325	.075x.325
AF	1.42	1.48			1.448	1.446	1.450	1.450
AG	0.833	0.853			.847	.845	0.842	0.845
AH	0.240	0.260			.250	.250	0.250	0.250
AI	0.261	0.266		Rev. C	.262	.262	0.262	0.262
AJ	0.189	0.194	Ref		.191	.191	0.191	0.191
AK	~~1.990~~ 1.97	~~2.010~~ 2.030		DS 12/07/18	1.998	1.992	2.004	1.999
AL	0.625	0.630			.6257	.6256	0.6257	0.6257
AM	101.75	105.75			103.75	103.75	103.75	103.75
AN	0.053	0.073			.063	.063	0.063	0.063
AO	0.926	0.946			.942	.942	0.941	0.943
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject					.0035	.003	.0035	0.001

Measured by:	DMK	**Date:**	12/09/02
Audited by:	RD	**Date:**	12-9-02
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	







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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. F6663

11-07-4

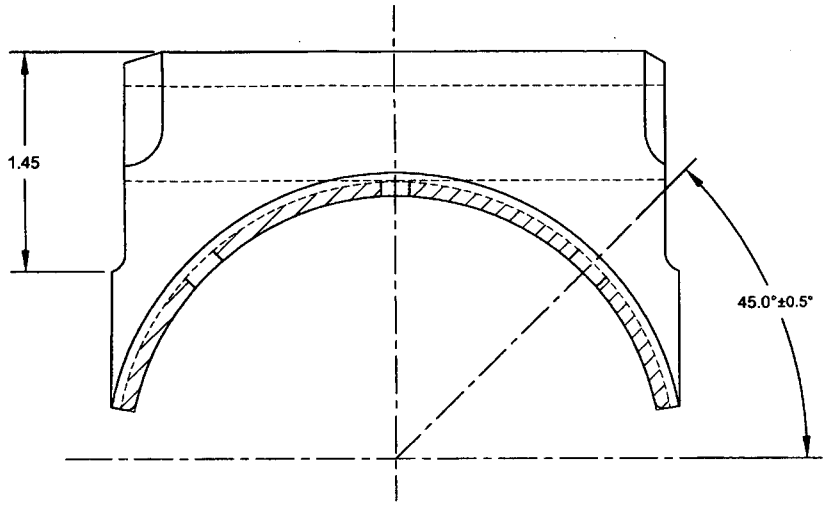
RELEASED
2011-09-29

D2896-1 SUPPORT

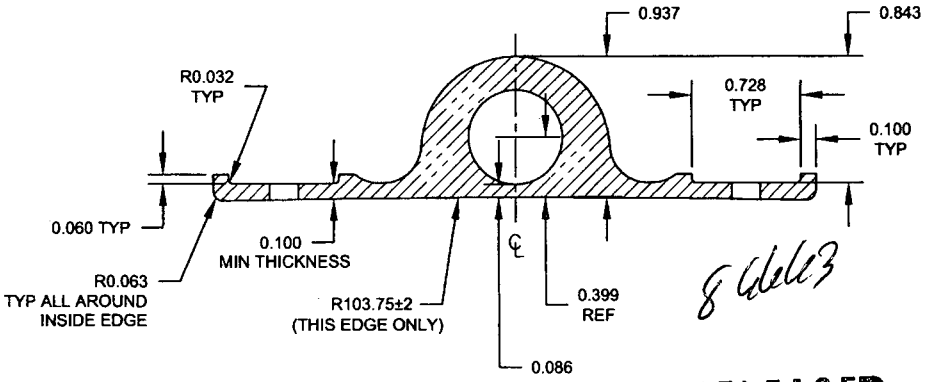
NOTES:
1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRc)
C 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
7) WEIGHT: 1.76 lbs

C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D2896	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	11.09.07		



SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



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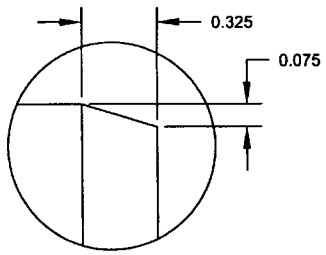
SCALE 2X



DETAIL C C6-1
SCALE 4X

RELEASED
2011-09-29

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2896	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	11.09.07		